

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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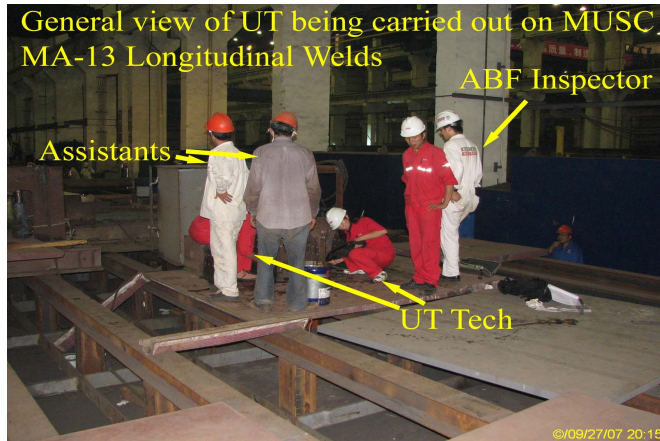
Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-000601**Date Inspected:** 27-Sep-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 1300**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2330**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Bing Xu and Xu Lefeng**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** 114 Meter Mock-Up**Summary of Items Observed:**

This Quality Assurance Inspector witnessed ultrasonic testing by ZPMC personnel on the 114 Meter Mock-Up, Skin Plate D, MA-113, weld joints 5, 8, 11 and 14 from the A and B sides of the T-joints. Each complete joint penetration weld was approximately 500 millimeters in length and all of the welds were rejected by ultrasonic testing. As testing was not completed until the end of the shift the cumulative defect lengths for each weld could not be obtained and the information was turned over to the next shift for data collection. The ZPMC ultrasonic testing technicians were Li Li Ming and E Shin Qin.

This Quality Assurance Inspector witnessed tack welding of the longitudinal stiffener plates on the 114 Meter Mock-Up, Interior Splice Assembly MUC-A58. The ZPMC welders were Gou Dengyun, welder identification 037997 and Li Dong, welder identification 066256. The amperage was checked and found to be 155 and the pre-heat was 140 degrees C.

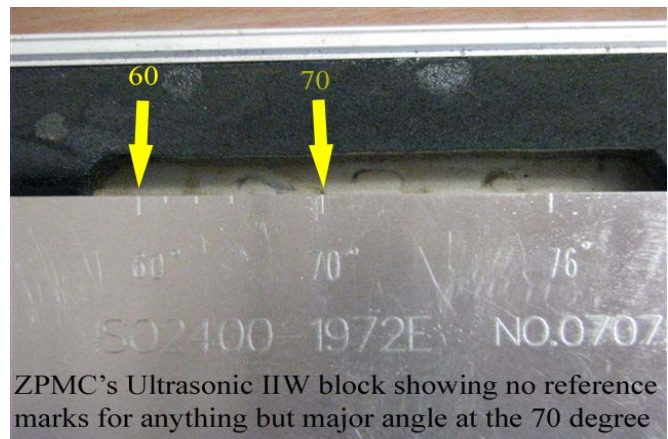
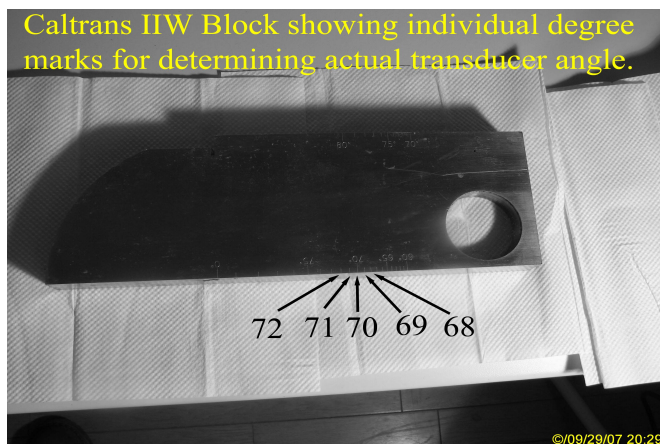
WELDING INSPECTION REPORT

(Continued Page 2 of 2)



Summary of Conversations:

Conversations were held with Mr. Fo Yo Fong and ZPMC Ultrasonic Technician Li Liming concerning the procedure for checking transducer angle and the db value used for scanning. Mr. Li Liming showed how the calculations were being used to determine the beam angle which was not in accordance with the ZPMC ultrasonic procedure submitted in the WQCP. Further in the discussion ZPMC explained that they do not use the required db value from the code for scanning level due to screen hash.



Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By: Berger, Bruce

Quality Assurance Inspector

Reviewed By: Cochran, Jim

QA Reviewer